



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2940-1
Job Sheet 206751



Part No: D2940-1

Job Qty: 10 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/20

Job Tracking No:

Due Date: 3/13/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2940 REV D IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G 11.08.04 as per dwg rev.C DD verf:EC/IPP Rev.H 19.10.01 DWG revision (ECN 19-829) DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs			2.00	23.81	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	10 pcs			0.00	0.00	QC 2 - 1		<i>De paron</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		<i>20/04/25</i>
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		<i>20/04/25</i>
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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CANADA
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Email: sales@dartaero.com
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Container No: S274175



Part: D2940-1

Job No: 206751

Serial No/Batch: S274175

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/28/20

			QC 2 - 8	
			QC 2 - 66	
			QC 2 - 64	
			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
120 QC 8	10 pcs	0.00 0.00	QC 8 - 12	
			QC 8 - 14	OK 20/06/27
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
130 Crosstubes - 2 - B4B	10 pcs	0.00 1.25	Crosstubes - 1 - B4B	
			Crosstubes - 2 - B4B	
			Crosstubes - 3 - B4B	DAS
			Crosstubes - 4 - B4B	'41 JUN 18 2020
140 QC 5	10 pcs	0.00 0.00	QC 5 - 10	9-89
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	QC5-82
				DAS 82 9-89 JUN 19 2020
				Plex 2/7/20 11:21 AM Dart.lajeunesse.marie

170 Packaging 3-1 - Stock - B4B 10 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
		Packaging 3 - 2 - B4B	
		Packaging 3 - 3 - B4B	
		Packaging 3 - 4 - B4B	
		Packaging 3 - 5 - B4B	
		Packaging 3 - 6 - B4B	
		Packaging 3 - 7 - B4B	
		Packaging 3 - 8 - B4B	
		Packaging 3 - 9 - B4B	
		Packaging 3 - 10 - B4B	
		Packaging 3 - 11 - B4B	
		Packaging 3 - 12 - B4B	
		Packaging 3 - 13 - B4B	
		Packaging 3 - 14 - B4B	
		Packaging 3 - 15 - B4B	
		Packaging 3 - 16 - B4B	
		Packaging 3 - 17 - B4B	
		Packaging 3 - 18 - B4B	
		Packaging 3 - 19 - B4B	
		Packaging 3 - 20 - B4B	
		Packaging 3 - 21 - B4B	DAS
		Packaging 3 - 22 - B4B	41 11/11/19 2020
		Packaging 3 - 23 - B4B	9.89
		Packaging 3 - 24 - B4B	
		Packaging 3 - 25 - B4B	
		Packaging 3 - 26 - B4B	
		Packaging 3 - 27 - B4B	
		Packaging 3 - 28 - B4B	
		Packaging 3 - 29 - B4B	
		Packaging 3 - 30 - B4B	
		Packaging 3 - 31 - B4B	
		Packaging 3 - 32 - B4B	
		Packaging 3 - 33 - B4B	
		Packaging 3 - 34 - B4B	
		Packaging 3 - 35 - B4B	
		Packaging 3 - 36 - B4B	
		Packaging 3 - 37 - B4B	
180 QC 21 - SA 10 pcs	0.00 0.00	QC 21 - SA - 21	DAS
		QC 21 - SA - 70	21 20-06-19
		QC 21 - SA - 53	2.89

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 110 - (QC8- Inspect parts - second check)

120 - (QC8- Inspect parts - second check)

130 - Per note 9 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

140 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____) LOCATION LG032 51

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	5 pcs (.5 ea)	100-HAAS 4 Axis	5244752 X3 5226363 X1 5257649 X1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK081	5	10	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633		
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493		
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350		
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640		
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 206751
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: 01	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.140	0.190		.170	.177	.16	.17	.165
AB	0.040	0.060		.048	.046	.046	.046	.048
AC	Ø0.187	Ø0.193		.19	.19	.19	.19	.19
AD	Ø0.260	Ø0.267		.262	.262	.262	.262	.262
AE	0.143	0.163		.154	.154	.151	.153	.153
AF	1.485	1.525		1.4975	1.5	1.498	1.5	1.5
AG	3.510	3.530		3.522	3.521	3.521	3.520	3.522
AH	0.350	0.450		.39	.39	.39	.39	.39
AI	4.930	4.990		4.957	4.957	4.958	4.958	4.958
AJ	0.140	0.180		.156	.16	.16	.16	.16
AK	0.140	0.180		.165	.167	.166	.17	.162
AL	2.322	2.342		2.329	2.331	2.33	2.329	2.331
AM	0.090	0.110		.100	.100	.100	.100	.100
AN	0.040	0.060		.0535	.053	.055	.053	.054
AO	0.140	0.160		.151	.1515	.152	.152	.1515
AP	R0.240	R0.260		R.25	R.25	R.25	R.25	R.25
AQ	R0.053	R0.073		R.063	R.063	R.063	R.063	R.063
AR	R0.053	R0.073		R.063	R.063	R.063	R.063	R.063
AS	R0.240	R0.260		R.25	R.25	R.25	R.25	R.25
AT	R0.470	R0.530		R.5	R.5	R.5	R.5	R.5
AU	R0.920	R0.980		R.95	R.95	R.95	R.95	R.95
AV								
AW								
Accept/Reject								

Measured by: [Signature]	Date: 20/04/27
Audited by: [Signature]	Date: 20/06/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	MC [Signature]	DP

DART AEROSPACE LTD		Work Order: 206751
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: 0.1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.140	0.190		.168	.168	.170	.171	.168
AB	0.040	0.060		.046	.048	.051	.048	.045
AC	Ø0.187	Ø0.193		.19	.190	.190	.190	.190
AD	Ø0.260	Ø0.267		.262	.262	.262	.262	.262
AE	0.143	0.163		.1545	.156	.155	.154	.156
AF	1.485	1.525		1.498	1.500	1.501	1.500	1.497
AG	3.510	3.530		3.519	3.520	3.519	3.522	3.521
AH	0.350	0.450		.39	.360	.360	.360	.360
AI	4.930	4.990		4.958	4.959	4.958	4.959	4.956
AJ	0.140	0.180		.16	.160	.148	.157	.165
AK	0.140	0.180		.172	.168	.172	.164	.174
AL	2.322	2.342		2.329	2.327	2.324	2.330	2.330
AM	0.090	0.110		.100	.104	.101	.102	.106
AN	0.040	0.060		.051	.053	.051	.053	.054
AO	0.140	0.160		.151	.151	.150	.155	.154
AP	R0.240	R0.260		R.25	R.25	R.25	.250	.250
AQ	R0.053	R0.073		R.063	.063	.063	.063	.063
AR	R0.053	R0.073		R.063	.063	.063	.063	.063
AS	R0.240	R0.260		R.25	.250	.250	.250	.250
AT	R0.470	R0.530		R.5	.500	.500	.500	.500
AU	R0.920	R0.980		R.95	.950	.950	.950	.950
AV								
AW								
Accept/Reject								

Measured by: DC / mme	Date: 20/04/08
Audited by: [Signature]	Date: 20/06/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	
F	20.02.04	Dwg Rev and dimensions updated	MM [Signature]	DP